



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D3560-041
Job Sheet 168767



Part No: D3560-041

Job Qty: 2 ea

Part Name: Arm Weldment



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/22/17

Job Tracking No:

Due Date: 12/8/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		12/7/17	0.00	0.00	Start Up Large Fab-2		D.M.L 17-12-14
130	Packaging	2 pcs		12/7/17	0.00	0.00	Packaging1		CPC DEC 14 2017
140	Large Fab	2 pcs		12/7/17	0.00	1.63	Large Fab 2		CPC
150	QC	2 pcs		12/7/17	0.00	0.00	QC5		PD 17-12-14
160	QC	2 pcs		12/7/17	0.00	0.00	QC9		PD 17-12-14
170	HandFinish	2 pcs		12/7/17	0.00	0.25	HandFinish1		BEB 17/12/15
180	QC	2 pcs		12/7/17	0.00	0.00	QC7		CPC
190	Small Fab	2 pcs		12/8/17	0.00	0.06	Small Fab		CPC DAS
200	QC	2 pcs		12/8/17	0.00	0.00	QC5		CPC 32
210	Packaging	2 pcs		12/8/17	0.00	0.00	Packaging3		CPC 32
220	QC21-SA	2 Ea		12/8/17	0.00	0.00	QC21		DEC 15 2017

Part Op 140 - 1-Weld assembly as per dwg D3560 STEP: 1- clean material (buff bracket and bottom of arm with blue pad) 2- set Descriptions: up bracket and arm on jig 3- preheat bracket and arm with torch 4- clean before welding with brush 5- set up machine to 135 amps 6- weld across bottom and top ends 7- reheat with torch (65 deg C) 8- on one side weld from bottom to top half way 9- same for other side (half way) 10- from half way point weld the rest of the first side (ease off pedal near end) 11- same for remaining side (ease off pedal near end)
190 - 1-Press bushing in D3560 arm per dwg D3562
210 - *** STOCK IN STEP CELL *** LOCATION: WA003

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	F149444 → D3560-1 F150436 → 1	2	6	0	0
	D3592-1 F149400	2	0	0	0
190-Small Fab	D2808 F164464	2	41	0	0

Part Specifications

Specifications could not be found.



S021840



Arm Weldment

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PART NO:

D3560 – 041

Revision:

Operation:

Start up Operation

Change No:

Mfg Date: 12/14/17

Job No: 168767